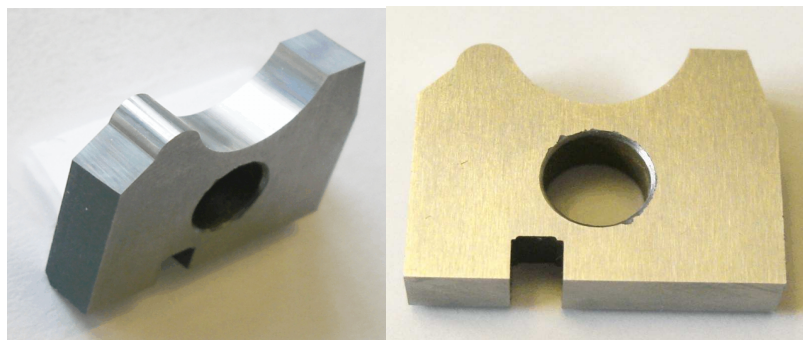













Singlesided Insert with ref. Notch

A08-300

The rectangular Insert is clamped using the PPC System (Precision Pin Clamping). All the sides are free for any grinding of profile, chipbreaking or referenceface operations. This specific inserts has a reference face and a reference notch. All of them are ground in one and the same cycle. Profilegrinding is based on the VSW grinding technology, where the sides of the V-shaped wheel fit tangential to the straight faces and convex parts of the profile.



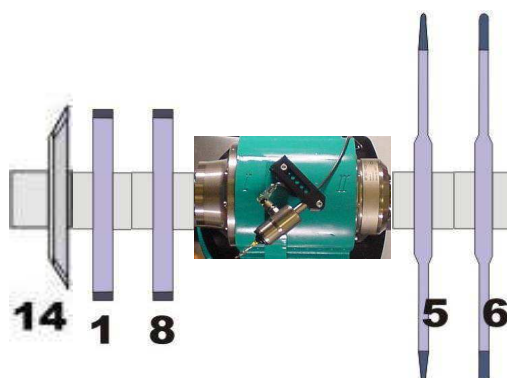
1. Cycletime for production

Tool specifications Diameter 16 mm, Cutting edges 1, Length of cutting edge 20 mm Material HM						
Operations						
Feed [mm/Min]	2000	25	85	110	60	60
Power [kW]		2	1	1	1	1
Cutting feed [m/s]		18	24	30	18	18
Used wheels						
Grinding time [s]	13	53	57	42	48	43
Total cycle time	4 Min 16					

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1 Ø300 1A1 D76
5 Ø300 14EE1 D91 VSW
6 Ø300 14EE1 D46 VSW
14 Ø125 1V1 D64
8 Ø125 1A1 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIR HPM
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.2, DXQ-Insert

responsible engineer: OP, 19.3.07

www.schneeberger.ch

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